

Work Order ID 64824

Friday, December 17, 2010 8:04:18 AM



Page 1

Item ID:	D3639-3	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Doubler					
Start Date:	12/16/2010	Start Qty:	6.00	Cust Item ID:		
Required Date:	1/19/2011	Req'd Qty:	6.00	Customer:		
Reference:						

Approvals:	Process Plan:		Date:	10-12-17	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3639	Rev A								

100	FLOW WATER JET	0.00							
	Waterjet								
FLOW CNC Waterjet	Memo	0.00							
2024 .050	1-Cut as per Dwg D3639	<input checked="" type="checkbox"/> Dwg Rev: A	<input type="checkbox"/> Prog Rev: A	<input type="checkbox"/> 2-					
	Deburr if necessary								68

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							

120	QC8- Inspect parts - second check	0.00							
	QC								
Quality Control	Memo	0.00							

5 11/01/03

68

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64824

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Page 2

Item ID: D3639-3

Accept

Revision ID:

Item Name: Doubler

Start Date: 12/16/2010 Start Qty: 6.00

Required Date: 1/19/2011 Req'd Qty: 6.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Form as per Dwg D3639

0.00

0.00

SB 11/01/04

(8)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

S 11/01/04

(28)

3

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4.1

Memo

0.00

0.00

=> ML 11/01/05

8

Ø

W/O:		WORK ORDER CHANGES					
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Page 3

Item ID: D3639-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Doubler

Start Date: 12/16/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 1/19/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

S BL 11-01-05

170

Identify as per dwg & Stock Location: 247

0.00



Packaging

Memo

0.00

Packaging

Per 11/01/06 (8)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 11/01/06
MF
11-01-06

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Friday, December 17, 2010 8:04:22 AM

Page 1

Work Order ID: 64824

Parent Item: D3639-3

Parent Item Name: Doubler




Start Date: 12/16/2010

Required Date: 1/19/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050  2024-T3 .050 sheet		Purchased	No			100	sf	92.3847	0.4277	2.701263	3.5 1811-1-3		

Location

Loc Qty

Loc Code

MAT22

92.3847

111381

11.89

113189

0.3947

114968

80.1

114968

68

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	44824
Description: Doubler		Part Number:	D3639-3
Inspection Dwg: D3639 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.625	+0.008/-0.001	1.625	✓		V HB02	
Ø0.191	+0.005/-0.001	1.191	✓		V	
Ø0.098	+0.004/-0.001	1.098	✓		V	
0.45	+/-0.030	1.454	✓		V	
1.350	+/-0.010	1.353	✓		V	
2.25	+/-0.030	2.253	✓		V	
3.15	+/-0.030	3.162	✓		V	
4.05	+/-0.030	4.055	✓		V	
4.95	+/-0.030	4.957	✓		V	
5.85	+/-0.030	5.855	✓		V	
6.75	+/-0.030	6.750	✓		V	
7.65	+/-0.030	7.655	✓		V	
8.55	+/-0.030	8.555	✓		V PRO HB2	
9.350	+/-0.010	9.356	✓		V PRO HB2	
9.45	+/-0.030	9.455	✓		V PRO HB2	
10.350	+/-0.010	10.352	✓		V PRO HB2	
11.25	+/-0.030	11.252	✓		T HB01	
12.15	+/-0.030	12.15	✓		T	
12.85	+/-0.030	BEND			T	
13.86	+/-0.030	13.86	✓		T	
13.96	+/-0.030	13.96	✓		T	
0.805	+/-0.010	1.805	✓		V	
1.00	+/-0.030	1.004	✓		V	
2.100	+/-0.010	2.098	✓		V	
3.30	+/-0.030	3.307	✓		V	
2.000	+/-0.010	2.000	✓		V	
2.590	+/-0.010	2.597	✓		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 11-1-3	Date: 11/01/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.24	New Issue	KJ/EC/DD	[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

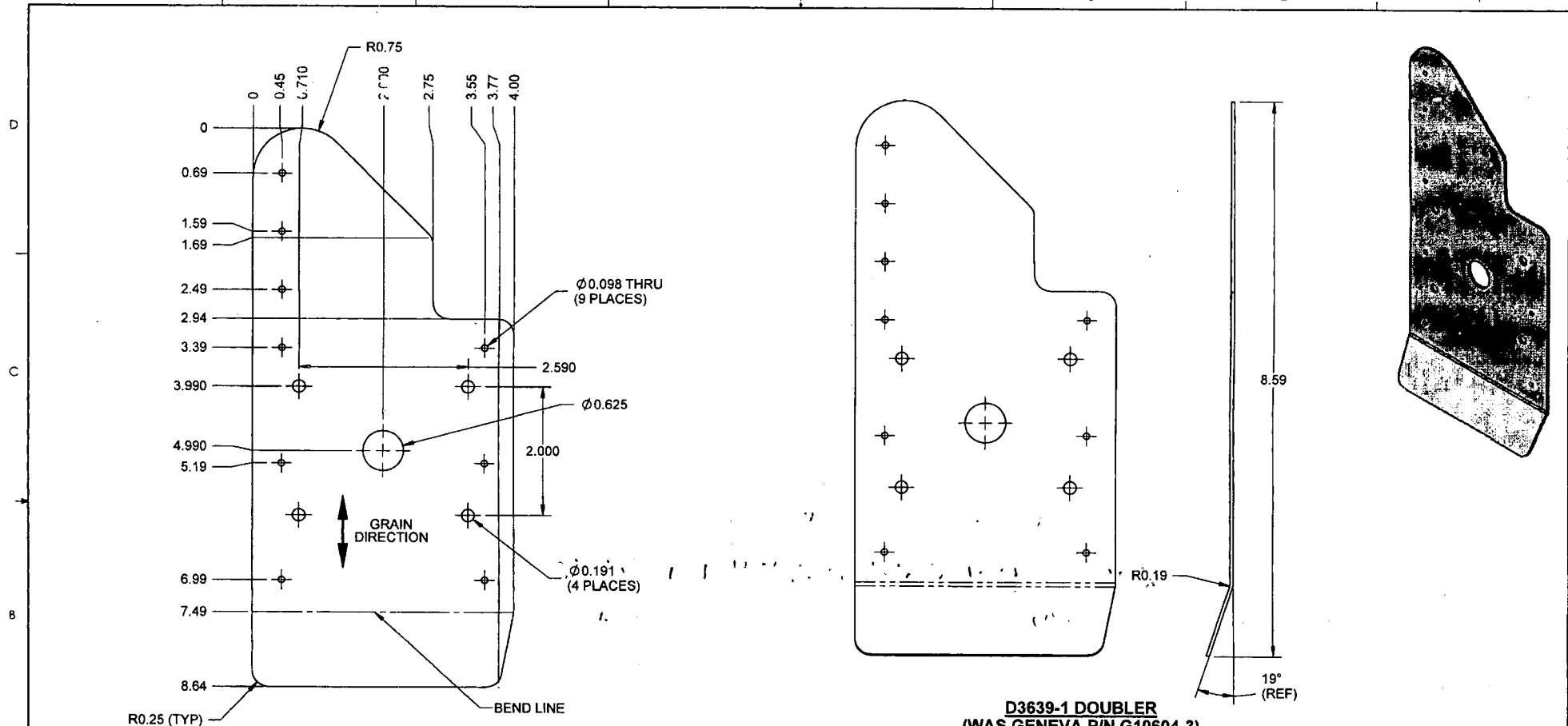
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



**D3639-1F FLAT PATTERN
(D3639-2F OPPOSITE)**

**D3639-1 DOUBLER
(WAS GENEVA P/N G10604-3)
D3639-2 OPPOSITE
(WAS GENEVA P/N G10604-6)**

RELEASED
07-07-27

- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-1/-2" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.14 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 64824

A	NEW ISSUE; REPLACES G10604	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS		
DRAWN	LE		
CHECKED	LE		
MFG. APPR.	FE		
APPROVED	FE		
DE APPR.	FE		
DATE	07.07.27		

DART AEROSPACE USA, INC.
PORT HADLOCK, WA
DRAWING NO. **D3639**
TITLE **DOUBLER**
REV. A
SHEET 1 OF 2
SCALE
2:3
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PL 1012-17

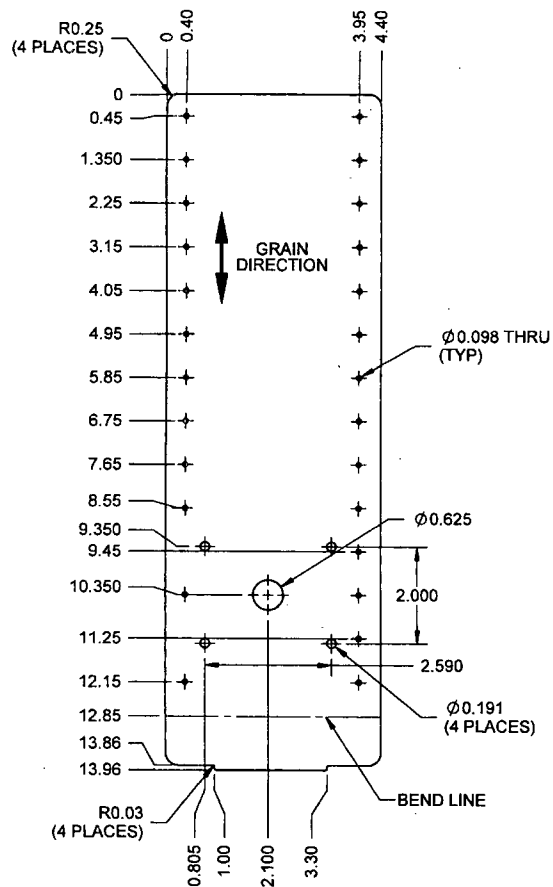
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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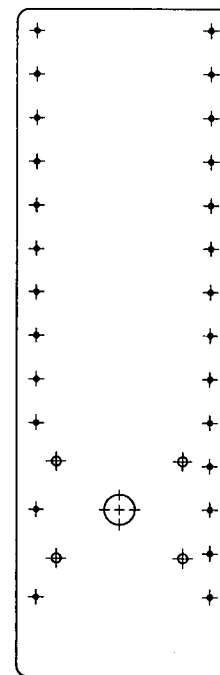
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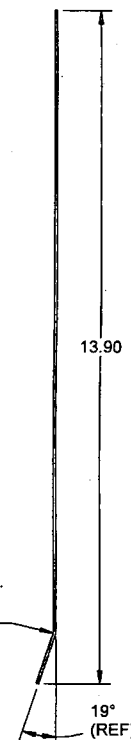


D3639-3F FLAT PATTERN
(D3639-4F OPPOSITE)

W/ 44824



D3639-3 DOUBLER
(WAS GENEVA P/N G10604-4)
~~D3639-4 OPPOSITE~~
(WAS GENEVA P/N G10604-5)



RELEASED
07.09.07 #

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-3/-4" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.3 lbs

DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	LE	PORT HADLOCK, WA	
CHECKED	JE	DRAWING NO.	REV. A
MFG. APPR.	JE	D3639	SHEET 2 OF 2
APPROVED	JE	TITLE	SCALE
DE APPR.	JE	DOUBLER	2.5
DATE	07.07.27	<small>COPYRIGHT © 2007 BY DART AEROSPACE USA, INC.</small> <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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